

SHIP

Work Order ID 58247

Sunday, May 02, 2010 1:19:59 PM



TUESDAY

Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Assembly (350)

Stop



Start Date: 5/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MP*

Date: 10-5-2010

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4030	B
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100	Pick Kit	0.00
-----	----------	------



Packaging

Packaging

10/5/10 - 0

110	Assemble as per dwg	0.00
-----	---------------------	------



HandFinish

Hand Finishing

10/5/10 - 0

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------



QC

Quality Control

S. Watson

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location:

0.00

DOP 58248

16-5-4

SL

Packaging

W/0 58248
Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/04 AJ

MR

10-5-4

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Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3917-3 Washer		Manufactured	No			100	Each	6.0000	6	58186	10	
D3953-3 Gas Spring Stud, Lid		Manufactured	No		ST096 57144	100	Each	9.0000	2	57144	58	
D3953-7 Spring Spacer		Manufactured	No		ST101 53757 57978	100	Each	17.0000	2	53757		
D3953-9 Gas Spring Washer		Manufactured	No		ST101 53970	100	Each	32.0000	2	53970	10/5/30	
					ST101 53642			32		53642		

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D3953-17		Manufactured	No			100	Each	10.0000	2	58186		
Gas Spring Spacer												
D3953-19		Manufactured	No							57143		
Gas Spring Bracket												
D3953-21		Manufactured	No							57607		
Gas Spring Bracket												
D3969-3		Manufactured	No							57145		
Spring (Basket Lid)												

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AN3-14A		Purchased	No			100	Each	102.0000	4			



Bolt

LocationLoc QtyLoc Code

ST351	102	
109754	2	
114330	100	

109754 28
114330

AN3-16A



Purchased

No

100

Each

75.0000

2

LocationLoc QtyLoc Code

ST352	75	
111965	5	
113845	50	
114523	20	

111965

AN5-17A



Purchased

No

100

Each

173.0000

4

LocationLoc QtyLoc Code

ST323	68	
114324	68	
ST339	105	
113538	5	
114330	100	

114324

Bolt

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AN4-12		Purchased	No			100	Each	56.0000		3		

Bolt

AN310-4	Purchased	No	<u>Location</u>		100	Each	67.0000	3	<u>Loc Qty</u>	<u>Loc Code</u>	
			ST357						56		
			104016						6		
			114292						50		

NUT

AN310C4	Purchased	No	<u>Location</u>		100	Each	84.0000	2	<u>Loc Qty</u>	<u>Loc Code</u>	
			ST139						30		
			114341						30		
			ST314						17		
			113845						17		
			ST349						20		
			114341						20		

Nut

ST349	Purchased	No	<u>Location</u>		100	Each	84.0000	2	<u>Loc Qty</u>	<u>Loc Code</u>	
			ST349						84		
			114306						84		

W/O:		WORK ORDER CHANGES							
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Page 6

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Start Date: 5/3/2010

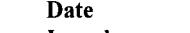
Required Date: 5/4/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			100	Each	1,776.000	6	~		
												

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1776	
113537	20	
113644	756	
114523	1000	
		113644

ST300	701	
113523	26	
113537	3	
114108	172	
114437	100	

114108

MS24665-151 Purchased No 114449 400 100 Each 704.0000 3  

Cotter Pin 

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Start Qty: 1.00

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Component Item ID/ Item Name	Item ID	Replacement Item ID	Mfg/ Purch	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS24665-300			Purchased				100	Each	94.0000	2			<i>h</i>

Cotter Pin

Location

ST309	94	
105279	2	
110123	92	

100	Each	93.0000	6
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NAS1149C0432R			No			100	Each	188.0000	2		6/10/10	✓

Washer

Location	Loc Qty	Loc Code
ST297	188	
114292	188	114292

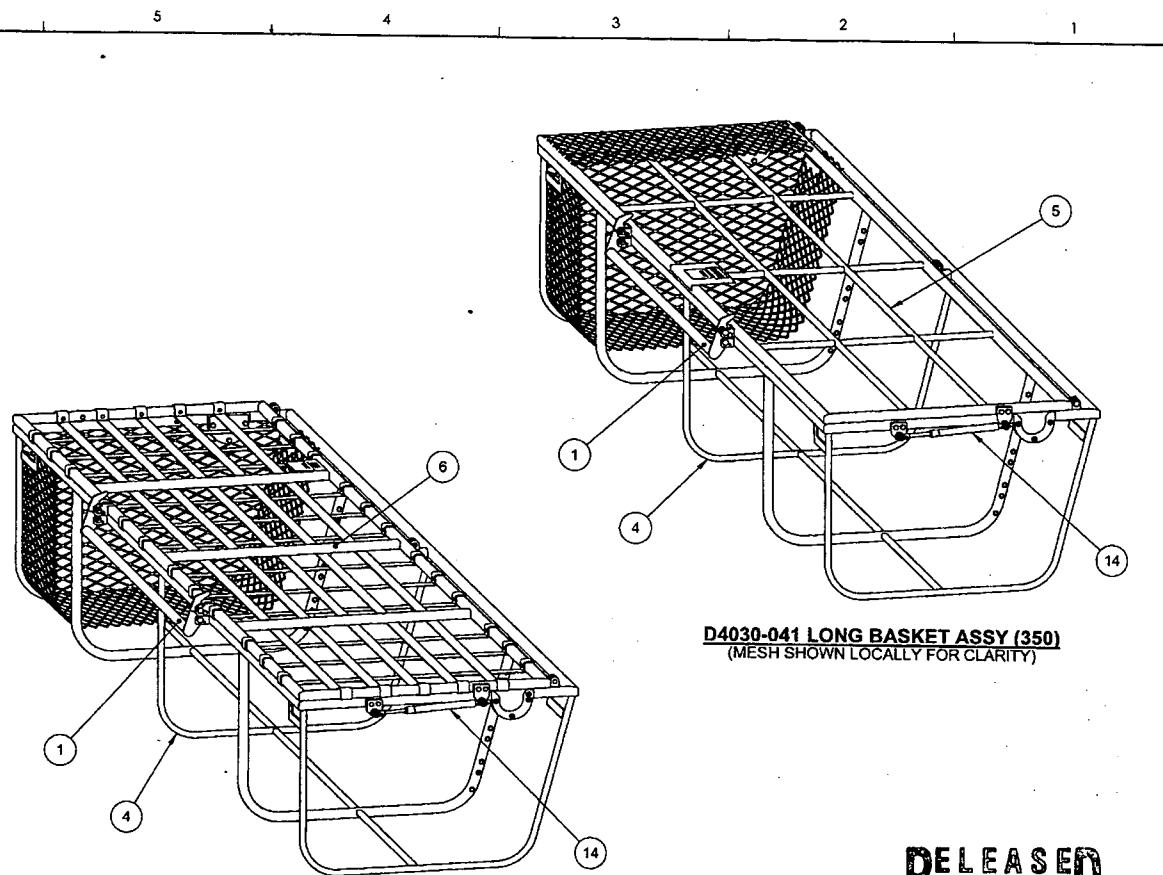
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
	X		D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6	1		D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17	2		AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20	2		ANS-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
29	8		NAS1149F0332P	WASHER
30	2		NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

B	ANS-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	REV. B	
APPROVED	<i>[Signature]</i>	SHEET 1 OF 3	
DE APPR.	<i>[Signature]</i>	TITLE	
DATE	10.04.06	SCALE	
LONG BASKET ASSY (350) NTS			

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RELEASED
2010-04-14

58247

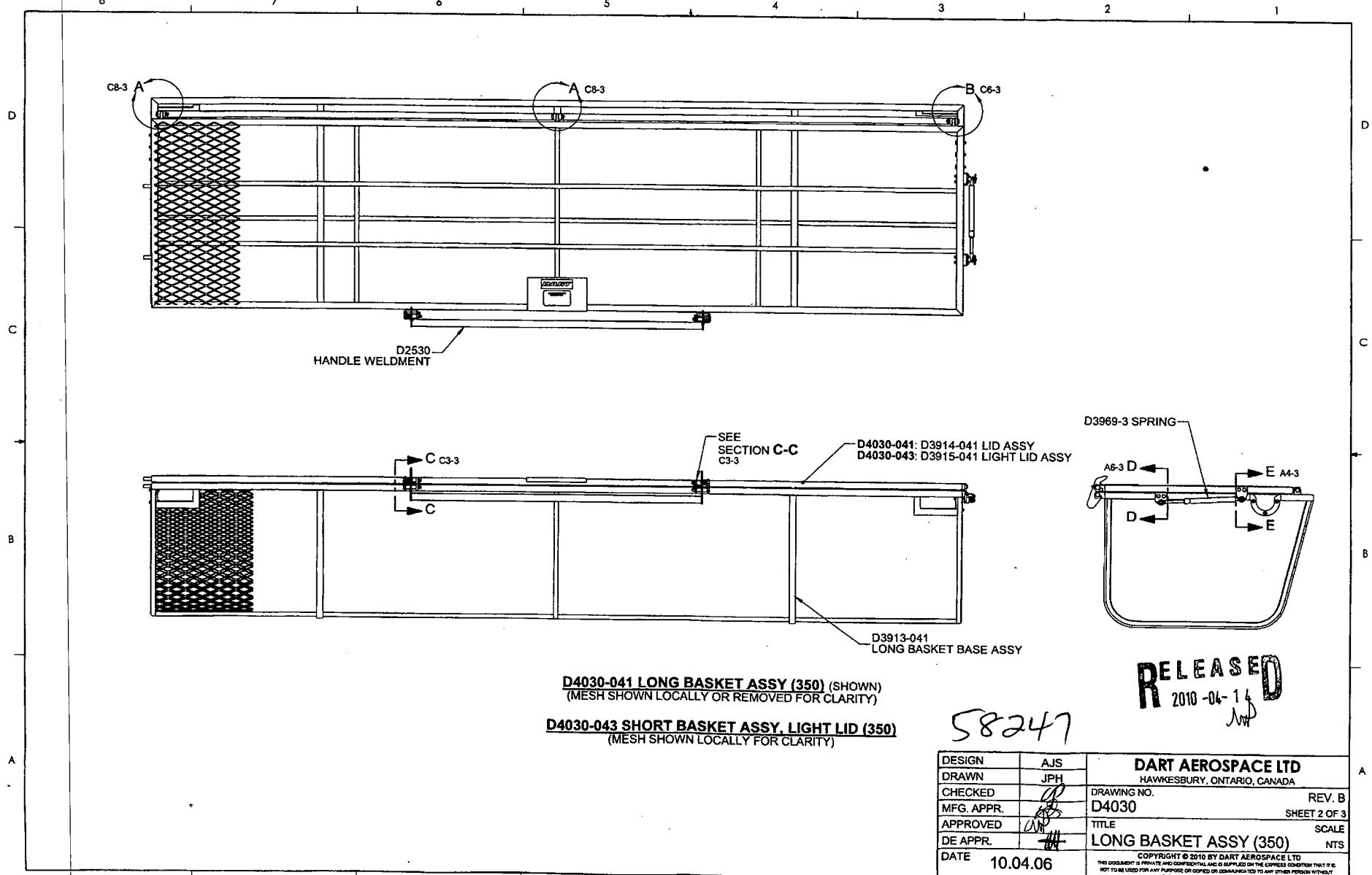
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



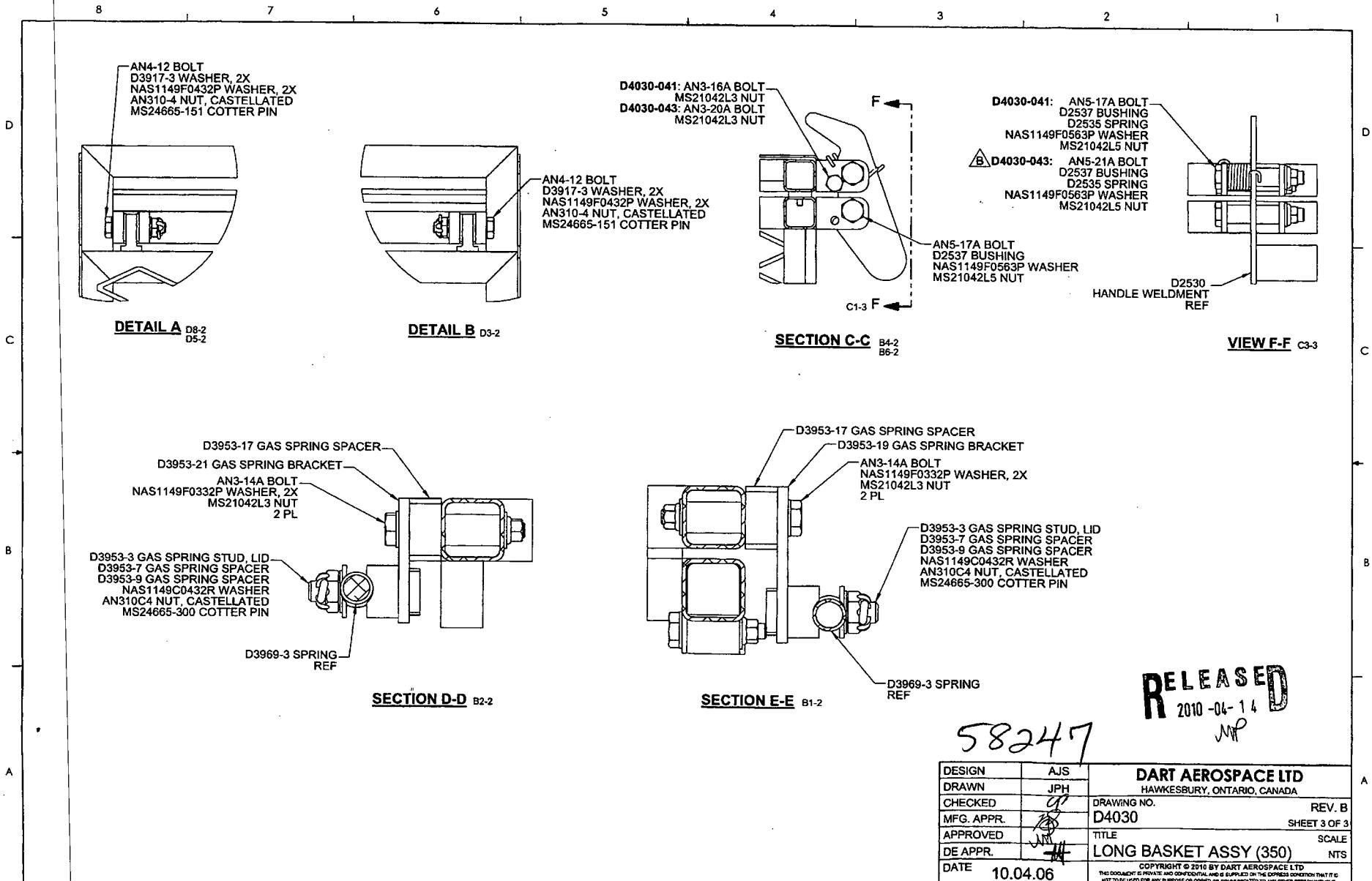
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
2010-04-14
MP

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	DRAWING NO.
MFG. APPR.	RS	D4030
APPROVED	JK	REV. B
DE APPR.	JK	SHEET 3 OF 3
DATE	10.04.06	TITLE
		SCALE
		LONG BASKET ASSY (350)
		NTS

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries